



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5785-3

Job Sheet 208155



Part No: D5785-3

Job Qty: 12 pcs

Part Name: Support



Part Weight: 0 lbs

Job Created: 3/12/20

Due Date: 3/31/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG 5785 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

30 pcs. **POSITIVE RECALL**

EFFECTIVE 26/3/12 AUTH SAN

RELEASED DATE

Priority: Medium



Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	12 pcs	3/31/20		0.50	0.48	SL-154 - 1	JB 20-03-13
							SL-2500Y - 1	
110	QC 2	12 pcs	3/31/20		0.00	0.00	QC 2 - 1	JB 20-03-13
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S263635



Part: D5785-3

Job No: 208155

Serial No/Batch: S263635

Revision: REV.A

Inspector:

Exp D:

In:

DAS
62
9-89

DAS
62
9-89

Plex 3/12/20 8:56 AM Dart.Renwick.Jennifer

				QC 2 - 65	
				QC 2 - 6	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
120 QC 2	12 pcs	3/31/20	0.00 0.00	QC 8 - 12	ML 20/03/14
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 59	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 67	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stack - B4B	12 pcs	3/31/20	0.00 0.00	Packaging 3 - 1 - B4B	MAC
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
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				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	

Plex 3/12/20 8:56 AM Dart, Renwick, Jennifer

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	12 pcs	3/31/20	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Machine as per folio FD198 FOLIO REV: AA DWG REV: A 2-Debur

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: QA 664)
 140 - (QC21- Final Inspection - Work Order Release)

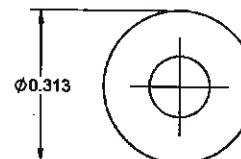
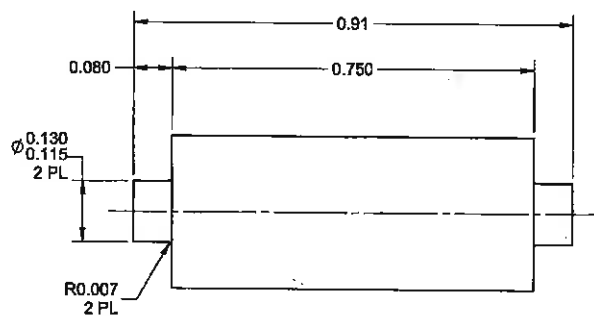
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304R0.313	304 SS Round bar .313	1.0500 ft (.0875 ea)	100-SL-154 - 1	<u>5123400</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M304R0.313	1	10	0

Part Specifications	
Specifications could not be found.	

Plex 3/12/20 8:56 AM Dart.Renwick.Jennifer

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208155



D5785-3 SUPPORT
(DERIVED FROM AERO DESIGN P/N 36275-02)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
2020 FEB 18 *N.D.*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5785	SHEET 3 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	HANDLE BRACKET	NTS
DATE	20.01.09	<small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DART AEROSPACE LTD'S PERMISSION</small>	

208155

D5785-3

Page 1 of 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041482

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5		M304B0.750X1.000		304 Bar 0.750 X 1.000" : MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$12.136866/ft	\$145.64
6		M304B1.000X1.250		304 Bar 1.000 X 1.250" : MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$20.227/ft	\$242.72
7		M304R0.313		304 SS Round bar .313 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$0.91/ft	\$10.92
8		M303R0.500		303 Round Bar 0.500" : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	36 ft	0 ft	36 ft	\$2.834/ft	\$102.02
9		M303R1.000		303 Round Bar 1.00 : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	24 ft	0 ft	24 ft	\$10.145/ft	\$243.48
10		M303R0.750		303 Round Bar 0.750 : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	24 ft	0 ft	24 ft	\$5.406/ft	\$129.74
11		M303B1.000X03.000		303 Bar 1" X 3" : MATERIAL: AISI 303 SS BAR AS PER ASTM A582 NOTE: AISI 304/316 NOT ACCEPTABLE receive ft	Firmed	-	11/1/18	12 ft	0 ft	12 ft	\$48.785/ft	\$585.42
12		M4130NT0.500W.083		4130 Round Tube .500 X .083W : MATERIAL: AISI 4130N STEEL TUBING AS PER MIL-T-6736 OR AMS 6371/6360/6361/6362 6373/6374 receive ft	Firmed	-	11/12/18	100 ft	0 ft	100 ft	\$14.50/ft	\$1,450.00

**ACIER OUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT

Copy

C000117760

Billed to

DART AEROSPACE LTD

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att : LUSSIER Tél.: (613) 632-5200 X 730

Instruction F-M**Delivery Route** 5**Customer N°**

CL10001056

Date

2018/10/29

Delivery date**2018/10/30****Your order N°**

PO041482

Processed by

Denis Quenneville

Salesman**Carrier**

OUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 HR SHEET 11G (4 X 8) 1251 FEH-11G48 2984 1 FEUILLE 48 X 96 Heat: (152886)	160.00	32.00	PI2_\$CLB		15' X 8'						
2 PLATE 44W 5/8 RANDOM P44-58-V 4128 1 PL. 4' X 4' Heat: (6913D4) M	408.00	16.00	PI2_\$CLB		4' X 4'		8' X 23'	✓			8' X 16' 4' X 4'
3 ROUND CR 1 5/8 1018 (R) RCR-158 5283 1 X 12' Heat: (41299AG) M	84.60	12.00	PI_\$CLB		12'						
4 ROUND SS 5/16 304 (R) RSS-516 5773 1 X Heat: (46862) M	3.12	12.00	PI_\$CLB		1 X 13 3/4"						
5 ROUND SS 1/2 303 (R) RSS-12303 5727 3 X Heat: (891B / 936L) M	24.01	36.00	PI_\$CLB		3 X 12 1/4"						
6 ROUND SS 1 303 (R) RSS-1303 8519 2 X Heat: (923R) M	64.08	24.00	PI_\$CLB		2 X 12 1/4"						
7 ROUND SS 3/4 303 (R) RSS-34303 5761 2 X Heat: (51049) M	36.05	24.00	PI_\$CLB		1 X 13 1/4" 1 X 13 1/4"						

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304R0.313

PO / BATCH NO.: P0041482 / S12342

DATE: 18/11/01

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 0.313"

QUANTITY RECEIVED: 12ft

THICKNESS RECEIVED: 0.313"

QUANTITY INSPECTED: 12ft

SHEET SIZE ORDERED: —

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	ASTM A276
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	MT: 46862
CORRECT MATERIAL IDENTIFICATION	Y (N)	
CORRECT M# ON THE MATERIAL	Y (N)	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC#18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u>	SIGNED OFF BY: _____
DATE: <u>18/11/01</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

BOLLINGHAUS STEEL Bollinghaus Steel, SA DIN EN ISO 9001:2008 TÜV CERT No. 01 100 030458	Abnahmeprüfzeugnis/Mit Test Certificate/Certif. de Qualidade EN 10204:2004 / 3.1		No.: / Nr.: / Nr.: 0000144527														
	Unsere Innere Verweisung / Our Int. Ref / Ref Int 5600041814 000070		Datum / Date / Data 01.08.2018														
Normen / Standards / Normas TYPE 304UNS S30400 and TYPE 304LUNS S30403 acc. to ASTM A276/A276M-17, ASTM A182/A182M-18, ASTM A193/A193M-17, ASTM A479/A479M-18, ASTM A320/A320M-17a, ASTM A314-15, ASTM A287-15 Pract. E, AMS QQ-S-763D, AMS 5639J, AMS 5647K, ASME SA479/SA479M-2017, ASME SA276, ASME SA182/SA182M-2017, ASME SA193/SA193M-2017, ASME SA320/SA320M-2017, NACE MR0175-2015, execution as per ASTM A484/A484M-18.																	
Kunde / Customer / Cliente		Endgültiger Kunde / Final Customer / Cliente Final															
Bestell Nr./Order Nr./Enc.Nr. C115288		Bestell Nr./Order Nr./Enc.Nr. C115288.07															
Produktgruppe / Product Group / Grupo Produto ASTM 304L FLAT 3/4 X 1"		Gewicht / Weight / Peso 975 lb		Bunde / Bundle / Atados 01													
Werkstoff-Nr. / Material-no. / Qualidade 1.4307		Werkstoff-Normbezeichnung / Material standard grade / Norma do material X 2 CrNi 18-9															
Beschreibung / Description / Descrição Stainless steel flat bars, hot rolled, heat treated, straightened and pickled. US DFM 252.225-7009: MELT SOURCE: Germany / MFG: Portugal.																	
Schmelze Nr. / Cast no. / Fundo no. 61055180		Chemische Analyse in % / Chemical composition in % / Análise química em %															
EA		C	0.022	Si	0.360	Mn	1.690	P	0.030	S	0.029	Cr	18.140	Ni	8.080		
EA		Mo	0.110	Co	0.210	Cu	0.520	N	0.070	Ti	0.002	-	-	-	-		
Proben Nr. / Test no. / Amostra no.	ASTM E399		ASTM A370		ASTM A370		ASTM A370		ASTM A370		ASTM A370		ASTM A370		ASTM A370		
	Kerbschlagarbeit / Impact Test / Resistência		Streckgrenze / Yield point / Tensão limite		Dehngrenze 1% point / Limit of extension		Zugfestigkeit / Tensile strength / Tensão de rotura		Dehnung / Elongation / Alongamento		Einschnürung / Reduction of area / Coef. de redução		Einschnürung / Reduction of area / Coef. de redução		Einschnürung / Reduction of area / Coef. de redução		
	(Charpy V)		Rp 0.2 %		Rp 1.0%		Rm		A5		A40		Z		Z		
	[J]		[Ksi]		[Ksi]		[Ksi]		[%]		[%]		[%]		[%]		
4038073.01.01		217.0		47		55		94		55.3		66.4		69.0		69.0	
Visuelle Kontrolle / Visual inspection / Inspeção visual		ASTM E10		ASTM A262 Practice E		ASTM A262 Practice E		ASTM A262 Practice E		ASTM A262 Practice E		ASTM A262 Practice E		ASTM A262 Practice E		ASTM A262 Practice E	
OK		162		OK		OK		OK		OK		OK		OK		OK	
ASTM A494		ASTM E112		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade		Werkstoffversandiger / Quality Control Representative / Inspector de Qualidade	
OK		8		OK		OK		OK		OK		OK		OK		OK	
Verwechslungsprüfung / Test of identity / Teste de identificação		Metakroskopische Untersuchung / Micrographic test		OK		OK		OK		OK		OK		OK		OK	
OK		OK		OK		OK		OK		OK		OK		OK		OK	
Bemerkungen / Remarks / Observações		OK		OK		OK		OK		OK		OK		OK		OK	
Country of origin: Portugal. No weld repair done. Material is free of mercury and radiation contamination.		OK		OK		OK		OK		OK		OK		OK		OK	
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OK		OK		OK		OK											

SPECIFICATION CONTROL DRAWING

△ PURCHASE MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
(NOTE: AISI 303 NOT ACCEPTABLE)

△ SPECIFICATION: ASTM A276 OR ASTM A240

PART NUMBER: M304B | T.TTT | X | WW.WWWW
 THICK | WIDTH

WHERE "T.TTT" = THICKNESS IN INCHES
AND "WW.WWWW" = WIDTH IN INCHES

△ EG. 0.5" x 3.0" BAR = M304B0.500X3.000
EG. 0.5" X 12.0" PLATE = M304B0.500X12.000

RELEASED
60 2010-11-30

C	ADDED PLATE TO PURCHASE MATERIAL. ADDED PLATE RELATES SPECIFICATIONS AND EG. CHANGED TITLE FROM 304/316 BAR TO 304/316 BAR/PLATE	MB	10.11.25
B	REFORMAT DOW ALSO SPEC (IN DS 1). REF PAR 05-000A	CP	09.07.15
A	NEW ISSUE	PH	05.08.10
REV	DESCRIPTION	BY	DATE
DESIGN	<i>PN</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>IS</i>	DRAWING NO	REV. C
CHECKED	<i>JS</i>	M304B	SHEET 1 OF 1
MFG. APPR	<i>JS</i>	TITLE	SCALE
APPROVED	<i>JS</i>	304/316 BAR/PLATE	NTS
DE APPR		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
DATE	10.11.25		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; gap: 5px;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					